Page 1 Work Order ID 51757 September 2, 2009 9:55:29 AM Setup Start Accept D2594-1 Item ID: **Revision ID:**  $\mathbf{C}$ Stop Plug, 205 Skidtube Item Name: Start Qty: 906.00 **Cust Item ID:** 03/09/2009 **Start Date:** Reg'd Otv 2906.90 **Required Date: 22/09/2009** Customer: Reference: Run Start Date: Tooling: Date: Process Plan: Approvals: Stop SPC (Y/N): Date: QC: Date: \_\_\_\_\_ Reject Accept Reject Insp. Draw Plan Set Up/ Draw Operation Sequence ID/ Number Stamp Qty Number Rev. Code Qty **Run Hours** Description Work Center ID **Revision Nbr** Draw Nbr Rev C D2594 0.00 100 >> 070763 841 Hardinge CNC LATHE SMALL 0.00 Hardinge Memo 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 Hardinge CNC Lathe Small max. QC2- Inspect parts off machine FAI/FAIB 110 841 6 0.00

120

QC8- Inspect parts - second check

0.00 H.A 09/09/08

841

Memo

0.00

Quality Control

Quality Control

C



Page 2

September 2, 2009 9:55:29 AM

Item ID:

D2594-1

Accept



Setup Start



Stop

Item Name: **Start Date:** 

Revision ID:

03/09/2009

Plug, 205 Skidtube

**Start Oty: 906.00** 

**Required Date: 22/09/2009** 

Reg'd Oty: 906.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_ Date: \_\_\_\_

Tooling:

Date:

Start Run

QC: Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

HandFinish

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ Run Hours Draw Number Draw Rev.

Plan Code

Reject Accept Qty

Reject Number

Insp. Stamp

Memo

Memo

START TIME:

0.00

0.00

mo 09/08/08

Qty

Hand Finishing

140

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

3 '3010 FINISH TIME:

M(12260

0.00

) o = ( o = 3:000 ~ DOVEN TEMPERATURE:

QC3- Inspect Part Finish

150

QC

Quality Control

Memo

### Work Order ID 51757

C



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September 2, 2009 9:55:29 AM

Item ID:

D2594-1

**Revision ID:** 

Item Name:

Plug, 205 Skidtube

**Start Date:** 

03/09/2009

Start Qty: 906.00 Reg'd Qty: 906.00

**Required Date: 22/09/2009** 

Date: \_\_\_\_\_

Accept

Setup Start



Stop

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Stop

Start



Sequence ID/ Work Center ID

160

Packaging

Description

Operation

Identify as per dwg & Stock Location:

Set Up/ **Run Hours** 

Bl 09-09-9. 0.00

Draw Number

**Cust Item ID:** 

**Customer:** 

Rev-Code

Draw Plan

Accept Qty

Reject Qty

Run

Reject Insp. Number

Stamp

Packaging

OC21- Final Inspection - Work Order Release

0.00

0.00

170

OC **Quality Control**  Memo

Memo

0.00

09 (09 01 ) mc 09-09-10

### **Picklist Print**

September 2, 2009 9:55:29 AM

Work Order ID: 51757

Parent Item: D2594-1RevC

Parent Item Name: Plug, 205 Skidtube

rarent item ivame: 1 lug, 205 Skidu

Comments:



Start Date: 03/09/2009

**Required Date: 22/09/2009** 

Start Qty: 906.00

Required Qty: 906.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M6061T6R0.625		Purchased	No			110	f	83.8100	49.6869			

6061-T6 Round Bar .625"

Warehouse	Loc Oty	Loc Code	
<b>Location</b>			
Main Warehouse			
MAT	83.81		
109733	5.72		- N 0-91-31 11
110250	18.09		6.7 52 020 104
111650	60		399 DFP 09/09/02

Page 1

DART AEROSPACE LTD	Work Order:	
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	0.058				
0.500	+/-0.010	0,500				
Ø0.625	+/-0.010	0.624				
Ø0.430	+0.000/-0.002	0.4295	J			
0.090	+0.000/-0.002	0.090				
0.045	+0.000/-0.002	0.0445				,
				١,	l ,	

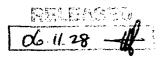
Measured by: Audited by: Prototype Approval: N/A

Date: 09/09/02 Date: CSOOO3 Date:

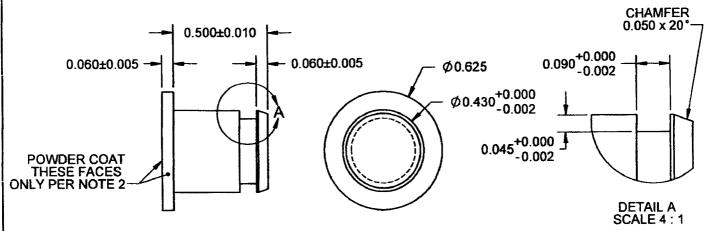
Rev	Date	Change	Revised by	Approved
Α	04.01.21	New Issue	KJ/RF	
В	06.12.20	Dwg Rev. updated	KJ/JLM 1/A	
С	08.07.23	Diameter symbol added	KJ/DD 9	



DESIG	#	DRAWN BY	DART AEROS HAWKESBURY, ONT	
CHECK	ŒD	APPROVED,/	DRAWING NO.	REV. C
1	E		D2594	SHEET 1 OF 1
DATE			TITLE	SCALE
Ţ	06.1	11.20	PLUG	2:1
REV		DATE	DESCRIP	TION
Α		96.09.16	NEWISSUE	
В		97.03.15	ADD GROOVE AND O-RIN	
С		06.11.20	ADD PWDR COAT; ADD M	S P/N TO D2594-3; )LERANCE NOTE



DATE	DESCRIPTION
96.09.16	NEW ISSUE
97.03.15	ADD GROOVE AND O-RING
06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE
	96.09.16 97.03.15



#### **D2594-1 PLUG**

D2594-1 PLUG NOTES:

1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 (2.3.5.1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

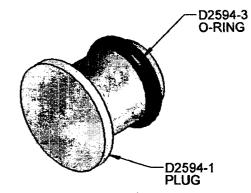
5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:
1) 5/16 ID, 7/16 OD, 1/16 WIDTH
2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011



QTY	P/N	DESCRIPTION
Х	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING





# **D2594 PLUG ASSEMBLY**

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